

23

Date: Wednesday, 5/16/2007 8:13:43 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
Job Number	: 32381		REVIEW
Estimate Number	: 10940	Part Number	: D29381 <i>up</i>
P.O. Number	: <i>N/A</i>	Drawing Number	: D2938 REV C
This Issue	: 5/16/2007	Project Number	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Revision	: C
First Issue	: <i>N/A</i>	Material	: <i>N/A</i>
Previous Run	: 30480	Due Date	: 6/6/2007
Written By	: <i>[Signature]</i>	Qty: -	16 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC		
	Est Rev: C As per Rev C 07-03-19 JLM		

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10	D6101003	7075-T7351 2X6.25X7.875
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**Comment:** Qty.: 1.0000 Each(s)/Unit      Total : 16.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88"      Grain Along 7.88" Length

(D6101-003)

Batch No:

B 25349

J.L/07/05/22

2:0 HAAS1™

## HAAS CNC VERTICAL MACHINING #1



**Comment:** HAAS CNC VERTICAL MACHINING #1

Program, part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

## 5-Deburr

heet  
heet  
J.L. / J.F. 07/25/24

3.0 MILLING CONV.

### CONVENTIONAL MILLING MACHINE



**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

Sp 07/07/07

4.0 Q'C1


INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F./En 07/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 07/07/11

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 5/16/2007 8:13:43 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 32381

Part Number: D29381

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mk 07/06/09*

*16*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*MS*

*07-06-11*

*16*

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

*N/A*

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *448*

*stock unpacked*

*07/11/09*

*12*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/07/09*

Job Completion



*07/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32381
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.116	.116	.117	.118		
B	0.100	0.140		.114	.116	.117	.118		
C	0.100	0.140		.118	.118	.118	.118		
D	0.210	0.230		.224	.222	.221	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.499	2.500	2.500		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.121	.121	.121	.120		
O	0.540	0.560		.550	.551	.550	.549		
P	0.490	0.510		.499	.498	.498	.501		
Q	3.715	3.725		3.719	3.719	3.719	3.719		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.250	.250	.251	.252		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.250	1.270		1.260	1.263	1.260	1.261		
Y	1.565	1.585		1.572	1.575	1.573	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JI	Audited by: JML
Date: 07/05/22 / 07/06/07	Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 32381
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.119	.119	.118	.119"		
B	0.100	0.140		.118	.119	.118	.119"		
C	0.100	0.140		.119	.119	.119	.125"		
D	0.210	0.230		.222	.220	.220	.225"		
E	1.245	1.255		1.250	1.250	1.250	1.252"		
F	1.245	1.255		1.250	1.250	1.250	1.250"		
G	2.495	2.505		2.500	2.500	2.500	2.502"		
H	0.510	0.515		.511	.511	.511	.511"		
I	1.572	1.582		1.577	1.577	1.577	1.580"		
J	2.495	2.505		2.500	2.500	2.500	2.500"		
K	0.257	0.262		.259	.259	.259	.259"		
L	0.312	0.317		.315	.315	.315	.315"		
M	0.235	0.240		.239	.239	.239	.237"		
N	0.100	0.140		.123	.122	.122	.123"		
O	0.540	0.560		.550	.549	.551	.551"		
P	0.490	0.510		.502	.498	.498	.502"		
Q	3.715	3.725		3.719	3.719	3.719	3.721"		
R	2.720	2.760		2.740	2.740	2.740	2.740"		
S	0.240	0.270		.250	.251	.250	.254"		
T	0.100	0.180		.140	.140	.140	.140"		
U	1.625	1.635		1.630	1.630	1.630	1.631"		
V	1.362	1.372		1.367	1.367	1.367	1.370"		
W	0.316	0.321		.320	.320	.320	.320"		
X	1.250	1.270		1.265	1.263	1.263	1.263"		
Y	1.565	1.585		1.577	1.576	1.576	1.576"		
Z	0.178	0.198		.188	.188	.188	.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L. / J.F. / E.M.	Audited by: [Signature]
Date: 07/05/23 / 07/06/23	Date: 07/06/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>32381</b>
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	<b>D2938-1</b>
<b>Inspection Dwg:</b> D2938 Rev. C		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.119"	.119"	.117"	.118"		
B	0.100	0.140		.120"	.122"	.121"	.121"		
C	0.100	0.140		.126"	.127"	.125"	.126"		
D	0.210	0.230		.224"	.225"	.225"	.225"		
E	1.245	1.255		1.250"	1.250"	1.252"	1.251"		
F	1.245	1.255		1.250"	1.250"	1.251"	1.252"		
G	2.495	2.505		2.501"	2.501"	2.503"	2.502"		
H	0.510	0.515		0.511"	0.511"	0.511"	0.511"		
I	1.572	1.582		1.581"	1.581"	1.581"	1.580"		
J	2.495	2.505		2.501"	2.502"	2.503"	2.501"		
K	0.257	0.262		0.258"	0.258"	0.258"	0.258"		
L	0.312	0.317		0.313"	0.313"	0.313"	0.313"		
M	0.235	0.240		0.231"	0.231"	0.231"	0.231"		
N	0.100	0.140		.123"	.123"	.123"	.123"		
O	0.540	0.560		.552"	.551"	.552"	.550"		
P	0.490	0.510		.504"	.504"	.504"	.505"		
Q	3.715	3.725		3.718"	3.722"	3.722"	3.724"		
R	2.720	2.760		2.740"	2.740"	2.740"	2.740"		
S	0.240	0.270		.253"	.258"	.254"	.254"		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.632"	1.632"	1.633"	1.632"		
V	1.362	1.372		1.370"	1.371"	1.369"	1.369"		
W	0.316	0.321		0.319"	0.319"	0.319"	0.319"		
X	1.250	1.270		1.262"	1.259"	1.261"	1.261"		
Y	1.565	1.585		1.576"	1.572"	1.575"	1.575"		
Z	0.178	0.198		A.188"	A.188"	A.188"	A.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <b>J.F.</b>	Audited by: <b>[Signature]</b>
Date: <b>07/05/24 / 07/06/07</b>	Date: <b>07/06/09</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<b>[Signature]</b>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>32381</b>
<b>Description: 206 Saddle, Outboard, Left side</b>	<b>Part Number:</b>	<b>D2938-1</b>
<b>Inspection Dwg: D2938 Rev. C</b>		<b>Page 1 of 1</b>

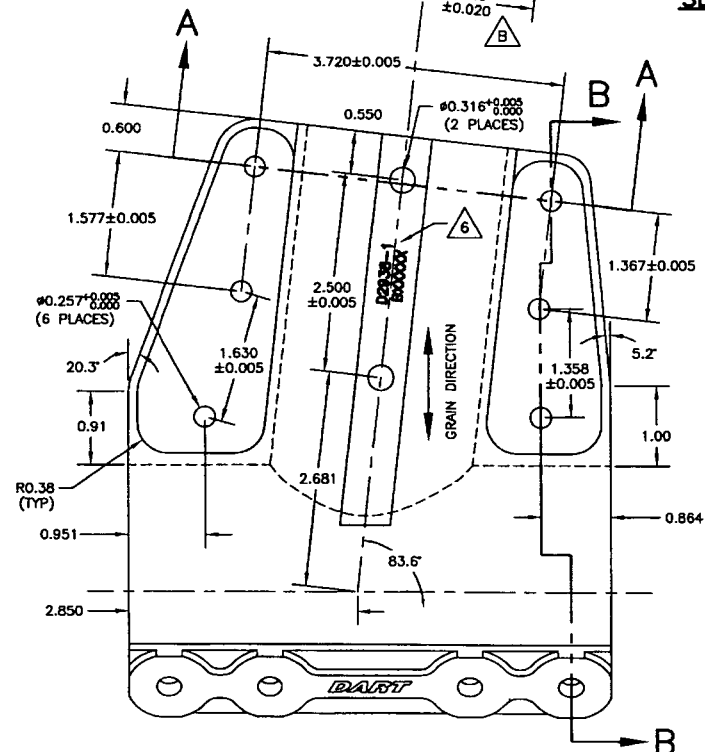
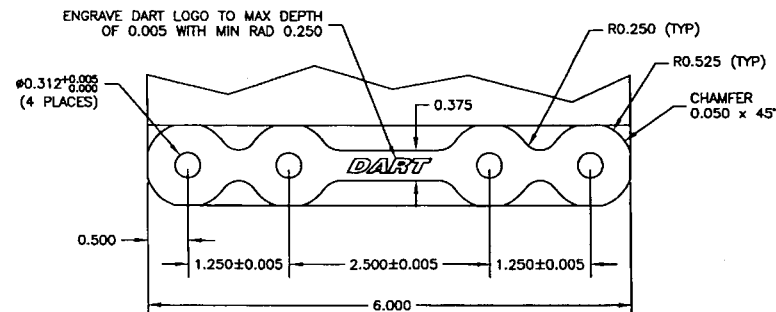
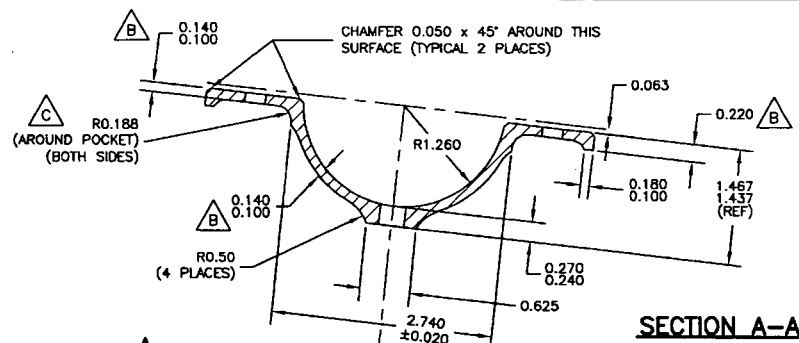
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.120"	.118"	.119"	.119"		
B	0.100	0.140		.120"	.120"	.122"	.122"		
C	0.100	0.140		.126"	.126"	.126"	.126"		
D	0.210	0.230		.254"	.256"	.226"	.226"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.251"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.502"	2.501"	2.501"	2.501"		
H	0.510	0.515		0.511"	0.511"	0.511"	0.511"		
I	1.572	1.582		1.582"	1.580"	1.580"	1.580"		
J	2.495	2.505		2.503"	2.501"	2.501"	2.501"		
K	0.257	0.262		Ø .258"	Ø .258"	Ø .258"	Ø .258"		
L	0.312	0.317		Ø .313"	Ø .313"	Ø .313"	Ø .313"		
M	0.235	0.240		Ø .239"	Ø .239"	Ø .239"	Ø .239"		
N	0.100	0.140		.124"	.123"	.123"	.123"		
O	0.540	0.560		.550"	.551"	.550"	.549"		
P	0.490	0.510		.502"	.504"	.502"	.502"		
Q	3.715	3.725		3.721"	3.722"	3.722"	3.722"		
R	2.720	2.760		2.740"	2.740"	2.740"	2.740"		
S	0.240	0.270		.254"	.255"	.255"	.255"		
T	0.100	0.180		.140"	.140"	.140"	.140"		
U	1.625	1.635		1.633"	1.633"	1.633"	1.633"		
V	1.362	1.372		1.370"	1.369"	1.369"	1.369"		
W	0.316	0.321		Ø .319"	Ø .319"	Ø .319"	Ø .319"		
X	1.250	1.270		1.262"	1.262"	1.261"	1.261"		
Y	1.565	1.585		1.575"	1.576"	1.575"	1.575"		
Z	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

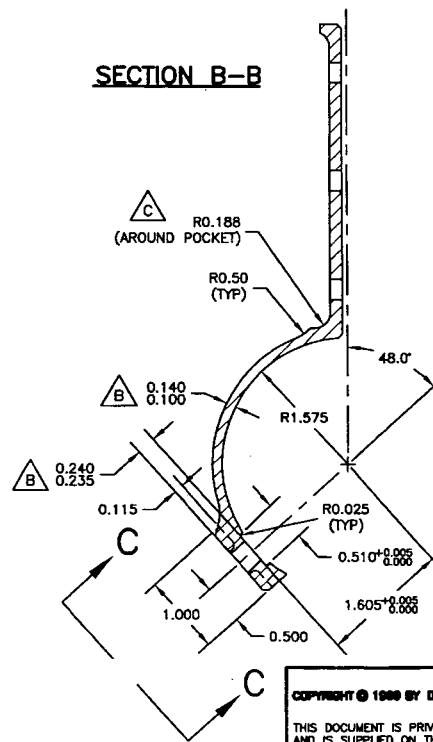
Measured by: <b>J.F.</b>	Audited by: <b>[Signature]</b>
Date: <b>07/05/24/07/06/07</b>	Date: <b>07/06/09</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<b>[Signature]</b>





SECTION B-B



D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2938
DATE	TITLE	SADDLE OUTSIDE
06.11.09		2.3

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07.02.12

NO. 32381

WORK ORDER

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ENGINEERING

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